

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-015708**Date Inspected:** 19-Jul-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 600**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1500**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** SAS OBG**Summary of Items Observed:**

The QA Inspector arrived on the job site in the am and observed no welding was being performed. The QA Inspector noted no production welding was ready to be performed in the am. The QA Inspector randomly observed the ABF Welding Superintendent Dan Ieraci and ABF helper removing the weld reinforcement at 5W/6W with the semi automated machine. The QA Inspector noted the weld reinforcement was approximately 60% removed upon the arrival of the QA Inspector.

5W/6W-D

The QA Inspector randomly observed the ABF welder Bryce Howell remove the fit up gear from the bottom side of the above identified weld joint. The QA Inspector noted the weld joint had only been tack welded from the inside, and the root pass or subsequent weld passes had not been deposited. The ABF welder informed the QA Inspector, he needed to remove the fit up gear to install the induction heat blankets in preparation of the submerged arc welding (SAW). Upon the arrival of the QA Inspector Danny Reyes and Jojo Lizardo, the QA Inspector informed the QA Inspectors to randomly verify the fit up did not move or shift after the fit up gear was removed. In addition the QA Inspector informed the QA Inspectors to randomly check the full length tack welds for any indication of shifting members.

The QA Inspector spent the remainder of the shift off site at Anamet Testing to witness the Charpy Vee Noch (CVN) specimens for the 1 ½" x ½" fracture critical steel backing bar (see TL-6032 for additional information).

WELDING INSPECTION REPORT

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Summary of Conversations:

as noted above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mohammad Fatemi (916)-813-3677, who represents the Office of Structural Materials for your project.

Inspected By:	Bettencourt,Rick
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Quality Assurance Inspector

Reviewed By:	Levell,Bill
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QA Reviewer
